

Ilion, New York  
February 20, 1962

**MODEL XP-700**  
**RIB and BARREL ASSEMBLY**

Details of this assembly are shown on drawing No. L-1321. Review of this drawing shows that the molded nylon rib is held on the barrel with five screws, four of these being threaded into studs and one threaded directly into the barrel.

The rear screw (Screw "A") serves only as an alignment screw with the added function of holding down the thin rearward end of the rib. The remaining screws are used to position and secure the rib and sight.

Screws "B", "D" and "E" serve the double purpose of holding both rib and sights. Examination of Section B-B (similar for screws "B", "D" and "E") reveals that the screws do not come in contact with the rib, but rather draw the sights toward the studs, thus forcing the rib down on the barrel. A gap of .020 inch is present between the sights and their respective studs when the screws are snugged down. As the nylon rib creeps under the compressive load, this gap is decreased until the sights come to bear on the studs. Under these conditions, the sights are secured directly to the barrel, and the rib is firmly secured.

Screw "C" functions somewhat differently from the others. Its purpose is merely to draw down and hold the center section of the rib. Section A-A shows in detail how this is accomplished.

A gap of .020 inch is present between the end of the screw and the bottom of the tapped hole when the screw is initially snugged

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down. As the screw is further tightened, nylon between the screw head and stud creeps and the screw base is caused to bottom in the tapped hole. This condition insures that the rib will remain tight in the barrel, and the screw will not become loose.

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